

2. (Amended) A method according to Claim 1 including a plurality of transverse security bars [extending between and into said stile members] and a plurality of upright security bars [extending between and into said rail members], and further comprising forming said stile members and said [transverse] rail members with flat, inwardly directed attachment flanges [across which said security bars pass], positioning said transverse security bars so that they pass across said attachment flanges of said stile members, and positioning said upright security bars so that they pass across said attachment flanges of said rail members wherein said security bars reside in contact with and are spot welded to said attachment flanges across which they pass.

3. (Amended) A method according to Claim 2 further comprising forming and positioning said attachment flanges in mutually coplanar relationship with each other to reside in a common plane and said step of spot welding is performed to attach said transverse security bars [that extend into and between said stile members] to said attachment flanges of said stiles [thereof] on one side of said common plane and said step of spot welding is performed to attach said upright security bars [that extend between and into said transverse rail members] to said attachment flanges of said rail members [thereof] on the opposite side of said common plane.

6. (Amended) A method according to Claim 5 further comprising initially cutting spot welding tip access apertures in said single, flat, sheet metal strip, thereby creating at least one spot welding tip access aperture in said hollow members at each of said corners, and spot welding said pairs of corner securing tabs to [said other of] said adjacent hollow members [adjacent thereto] by inserting internal spot welding tips into said spot welding tip access

apertures so as to contact said corner securing tabs within said adjacent hollow members, bringing external spot welding tips into external contact with said adjacent hollow members and passing electric currents between said internal and said external spot welding tips to spot weld said hollow members together at each of said corners.

7. (Amended) A method of fabricating a metal security door comprising:

forming four hollow metal door perimeter segment members so as to define a plurality of security bar receiving openings in each of said perimeter segment members,

5 positioning a plurality of metal security bars to project through said security bar receiving openings and into said hollow perimeter segment members so that said ends of said metal security bars terminate within said perimeter segment members and positioning said perimeter segment members together to form a rectangle, and

spot welding said ends of said metal security bars to said perimeter segment members within which they terminate.

8. (Amended) A method according to Claim 7 further comprising roll forming said hollow segment members so as to create a security bar attachment flange on each of said hollow perimeter segment members, whereby when said perimeter segment members are

5 positioned together to form said rectangle said attachment flanges all project inwardly within said rectangle and lie in a common plane, and whereby said security bar receiving openings in each of said perimeter segment members reside proximate to said security bar attachment flange thereof on one side of said common plane while said security bar receiving openings in each adjacent perimeter segment member lie on the opposite side of said common plane.